

Date: Tuesday, 19/08/2008 4:03:56 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 41428					
Estimate Number	: 10267					
P.O. Number	:			Part Number	: D2438	
This Issue	: 19/08/2008		S.O. No.	: D2438 REV. C		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: PURCHASED PARTS		
Previous Run	: 39440			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08-8-19</u>			Due Date	: 30/09/2008	
Comment	: Est: E 05.06.28 Bending removed KJ/JLM			Qty:	200	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>2002</u> <i>2008/08/21</i> Laser cut as per Dwg D2438 Material release note is required <i>(200)</i>
2.0	D2438B	Clamp
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) CLAMP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>(200)</i>
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2438 (6.786" center to center) <i>center</i> <i>4200</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr any rough edges <i>B 8-10-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 41428

Part Number: D2438

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S08/017 X200 corrente

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



sq

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 456

8/10/20

200X

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/20 fJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

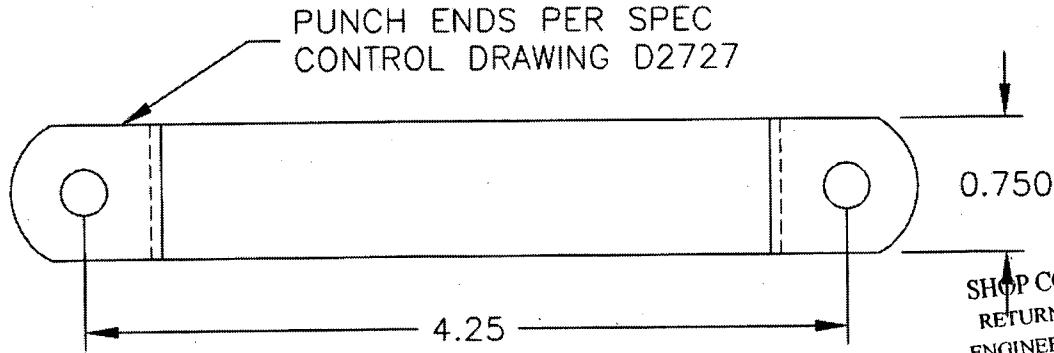
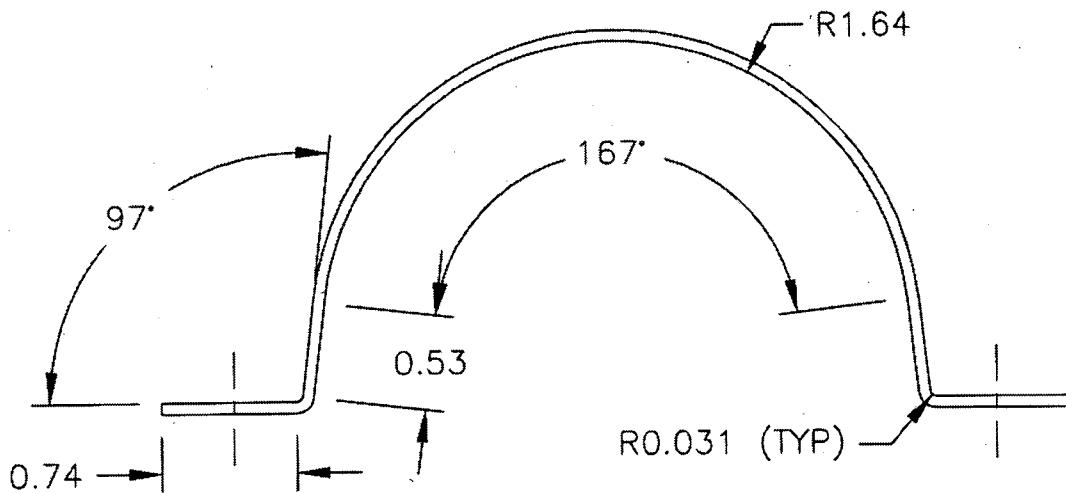
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

COPY ISSUE

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PWS</i>	APPROVED <i>Q</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KS

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 411638

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/09/15	0402771

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

QUANTITÉ QUANTITY	CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PONO.	VIA SHIP VIA
				DESCRIPTION
200	DART GFI-0299	J0189516	P000007002	CLAMP
				S 08/09/08

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	18	OUR JOB NO	J0189516	SHIPPING MEMO	0402771	<i>Stock 108</i>
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	200 PCS	PO00007002	D2438B	C	CLAMP	C
MATERIAL	SUPPLIED BY				MAT. REL. NO.	
S.S.T 304	TW METALS / NORTH AMERICAN				2M89	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **16 SEPTEMBER 2008**

G.F.I. Q.C. REP.

~~APR-04 Revision~~ Bombardier Certificate of Compliance
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GFI

PURCHASE ORDER No. 0073680

ITEM No. 0001 SHIPPER INVOICE No. 03235765

MATERIAL 304 S/S Sheet SPECIFICATION: ASTM A 240/06

MANUFACTURING MILL: North American Stainless

SIZE .0625 HEAT / LOT No. 2M39

(
calico

PART No. JS06348X964A QUANTITY: 206 15

TEST DEPARTMENT CLERK Sarje Clark

AUTHORITY

Joe Schab
Director of Quality Assurance



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

**6870 Highway 42 East
Chent, KY 41045-9615
(502) 347-6000**

Certificate: 363977 01
Customer: 0018 001

Ship To:
FERGUSON METALS INC
3475 SYMMES ROAD
HAMILTON, OH 45015

Date: 8/06/2007 Page: 1

Steel: 304/304L

Finish: 21

Corrosion: ASTM A262/02aE; 180 Bend -OK

Your Order:01009951

NAS Order: AN 0371411 0

PRODUCT DESCRIPTION

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/06b, 480/06b, 666/03, ASMESA 240/04-A05, 480/04-A05, SA666/04
QQS766D-A XMGPROM, AM95511H/5513H XMRK&FN, MIL4043B, AMD3, XCRNMEAS&FN * Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
042MB9 A	* 042MB9 A	.0620	48.0000	13,230 COIL	1299.8	11	1	
042MB9 B	* 042MB9 B	.0620	48.0000	13,330 COIL	1309.6	11	1	

08/08/13

C H E M I C A L A N A L Y S I S CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa)

Heat	CM	C	CO	CR	CU	MN	MO	N	NI	P	S	SI
2MB9	US	.027	.115	18.194	.254	1.795	.249	.077	8.120	.033	.001	.41

VI METALS

MECHANICAL PROPERTIES

Product ID #	Coil #	l o c r	d i r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
042MB9 A	042MB9		F T	99.31	51.02	51.13	88.00	85.5
042MB9 B	042MB9		F T	99.31	51.02	51.13	88.00	85.5

REVIEWED BY Q.C
Date 8/6/07 by G

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HES

8/9 207